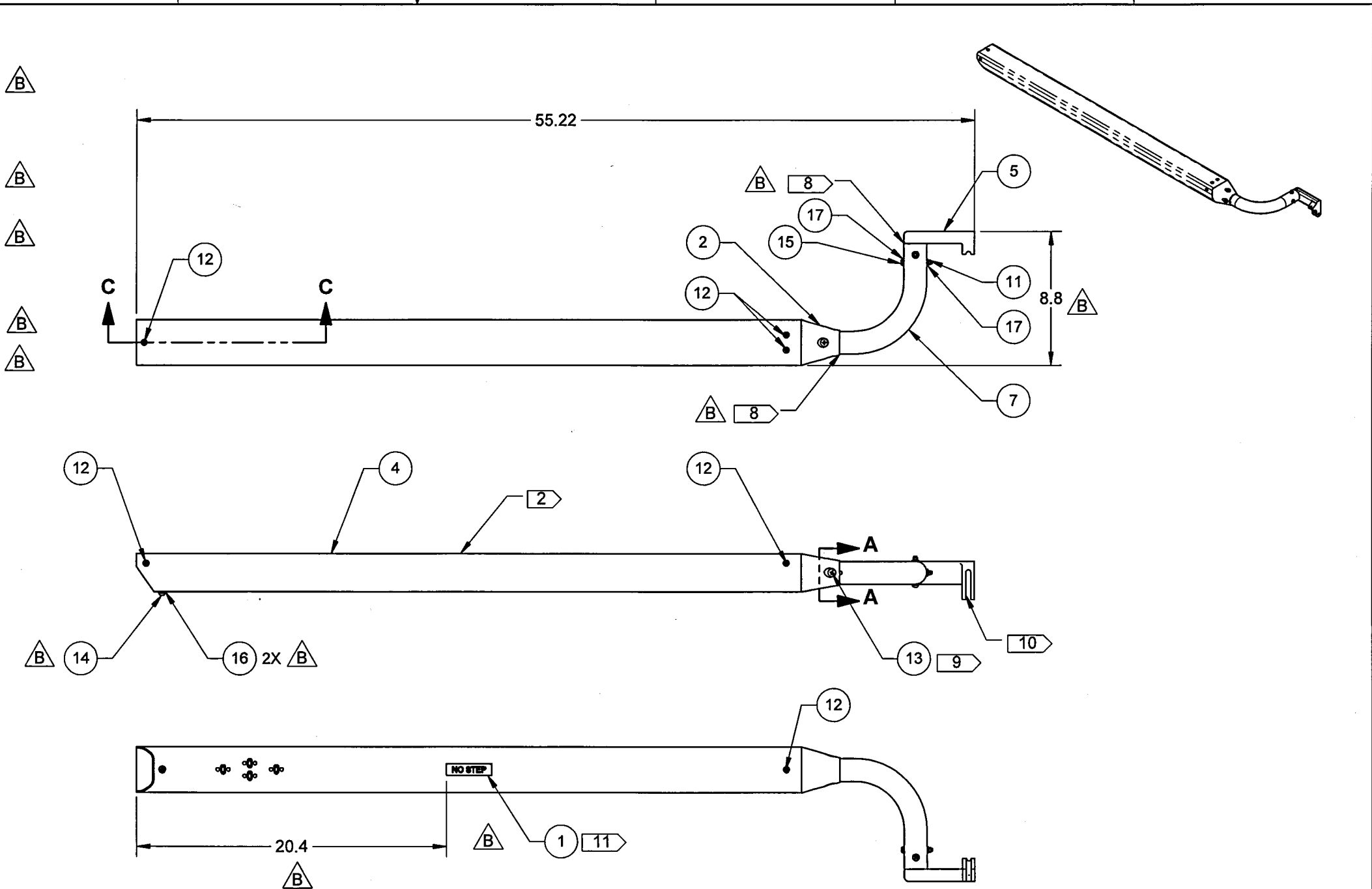


ITEM	QTY.	P/N	DESCRIPTION
	X	D5491-041	STEP ASSEMBLY
1	1	D2137	DECAL - NO STEP
2	1	D5273-043	END FITTING ASSEMBLY
3	3	D5291-041	ANCHOR NUT ASSEMBLY
4	1	D5491-1	STEP EXTRUSION
5	1	D5499-1	AFT BRACKET MOUNT
6	4	D5625-1	RECEPTACLE
7	1	D5627-1	TUBE
8	1	D5629-041	END CAP ASSY
9	8	CR3242-4-04	RIVET
10	6	CR3212-4-05	CSK RIVET, CHERRY MAX
11	2	MS21042L3	NUT, SELF-LOCKING
12	8	MS24694-S50	SCREW, CSK 100°
13	3	MS24694-S98	SCREW, CSK 100°
14	1	MS27039-1-10	SCREW, PAN-HEAD
15	2	MS27039-1-30	SCREW, PAN-HEAD
16	2	NAS1149D0332J	WASHER
17	4	NAS1149D0363J	WASHER



D5491-041 STEP ASSEMBLY

RELEASED

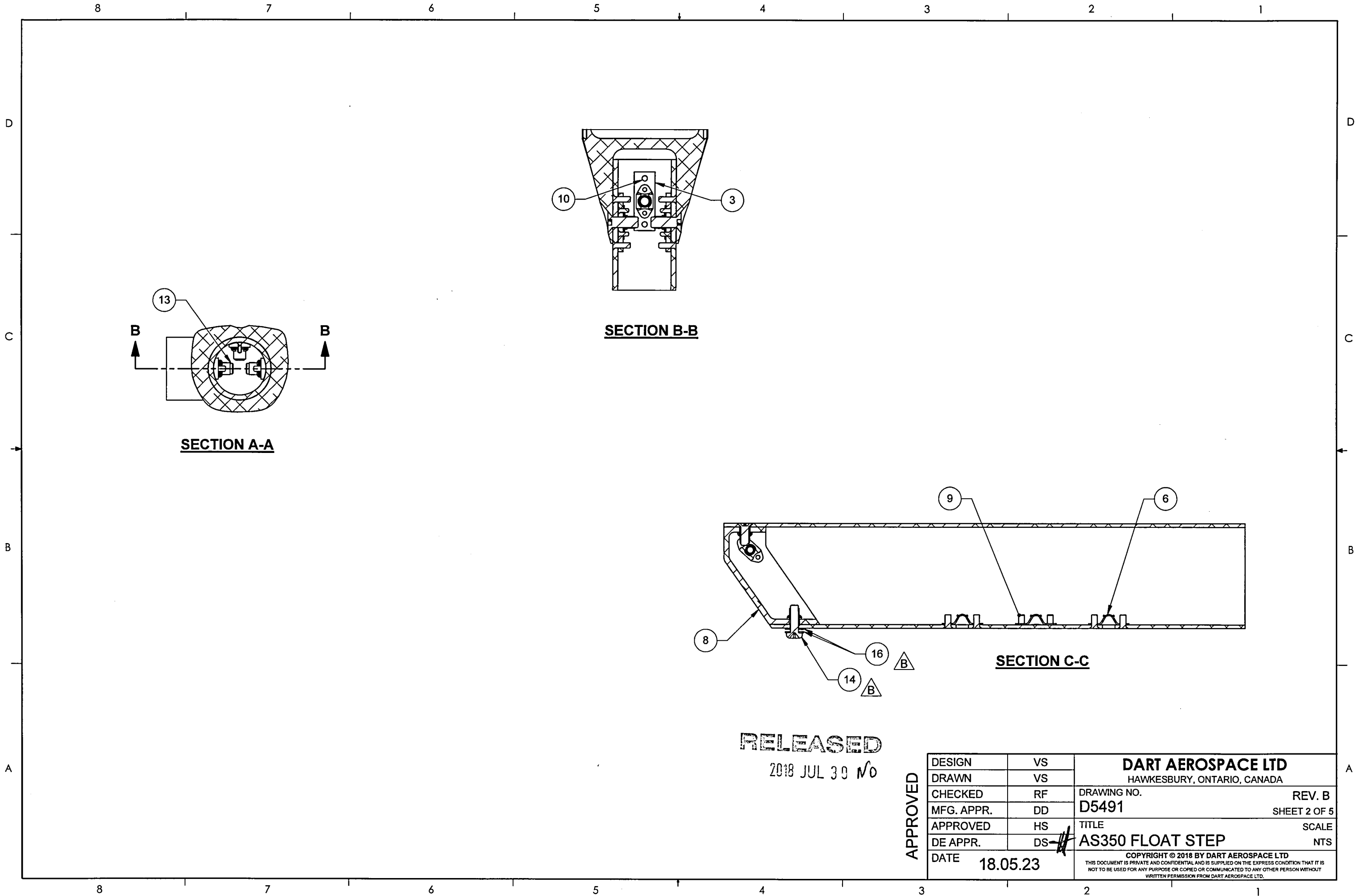
2018 JUL 30 NO
ECN18-749

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 AND PAINT PER DART QSI 005 4.2.2.4 MASK SCREWS, APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.80 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10384
- 9) TRANSFER DRILL FROM D5273-043 END FITTING ASSEMBLY TO D5627-1 TUBE
- 10) MASK SLOT PRIOR TO PAINT
- 11) INSTALL PLACARD IN ORIENTATION SHOWN ON BOTTOM SIDE OF STEP AFTER PAINTING

B	ADDED SHEET 2 AND 4; REVISED TOLERANCE (ZN C4-1, C8-3); ADDED 1X D5621-1 AND 2X CR3242-4-04 (ZN D6-1, D6-3); ADDED SLOT (ZN B6-5); REVISED EXTRUSION LENGTH (ZN C5-5); ADDED MS27039-1-10 AND NAS1149D0332J (ZN D6-1, ZN D6-3); REMOVED C'SINK (ZN B8-5); ADDED D2137 (ZN D6-1, D6-3); ADDED NOTE 11 (ZN A8-1, A8-3); REVISED NOTE 2 (ZN A8-1, A8-3)	VS	18.05.23
A	NEW ISSUE	VS	18.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5491	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AS350 FLOAT STEP	NTS
DATE	18.05.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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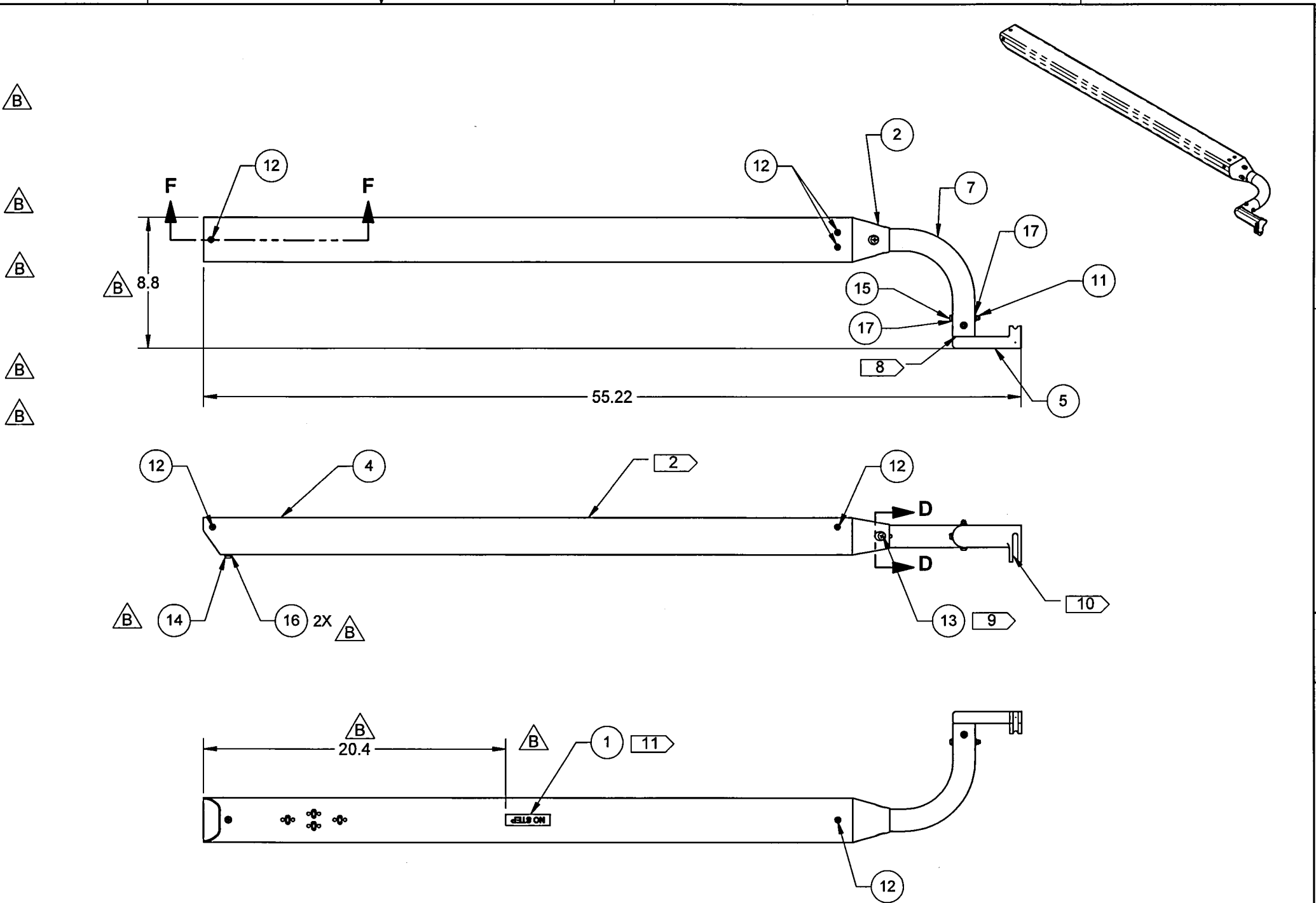


RELEASED
2018 JUL 30 No

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	RF	DRAWING NO. REV. B
MFG. APPR.	DD	D5491 SHEET 2 OF 5
APPROVED	HS	TITLE SCALE
DE APPR.	DS	AS350 FLOAT STEP NTS
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ITEM	QTY -042	P/N	DESCRIPTION
	X	D5491-042	STEP ASSEMBLY
1	1	D2137	DECAL - NO STEP
2	1	D5273-043	END FITTING ASSEMBLY
3	3	D5291-041	ANCHOR NUT ASSEMBLY
4	1	D5491-1	STEP EXTRUSION
5	1	D5499-2	AFT BRACKET MOUNT
6	4	D5625-1	RECEPTACLE
7	1	D5627-1	TUBE
8	1	D5629-041	END CAP ASSY
9	8	CR3242-4-04	RIVET
10	6	CR3212-4-05	CSK RIVET, CHERRY MAX
11	2	MS21042L3	NUT, SELF-LOCKING
12	8	MS24694-S50	SCREW, CSK 100°
13	3	MS24694-S98	SCREW, CSK 100°
14	1	MS27039-1-10	SCREW, PAN-HEAD
15	2	MS27039-1-30	SCREW, PAN-HEAD
16	2	NAS1149D0332J	WASHER
17	4	NAS1149D0363J	WASHER



D5491-042 STEP ASSEMBLY

NOTES:

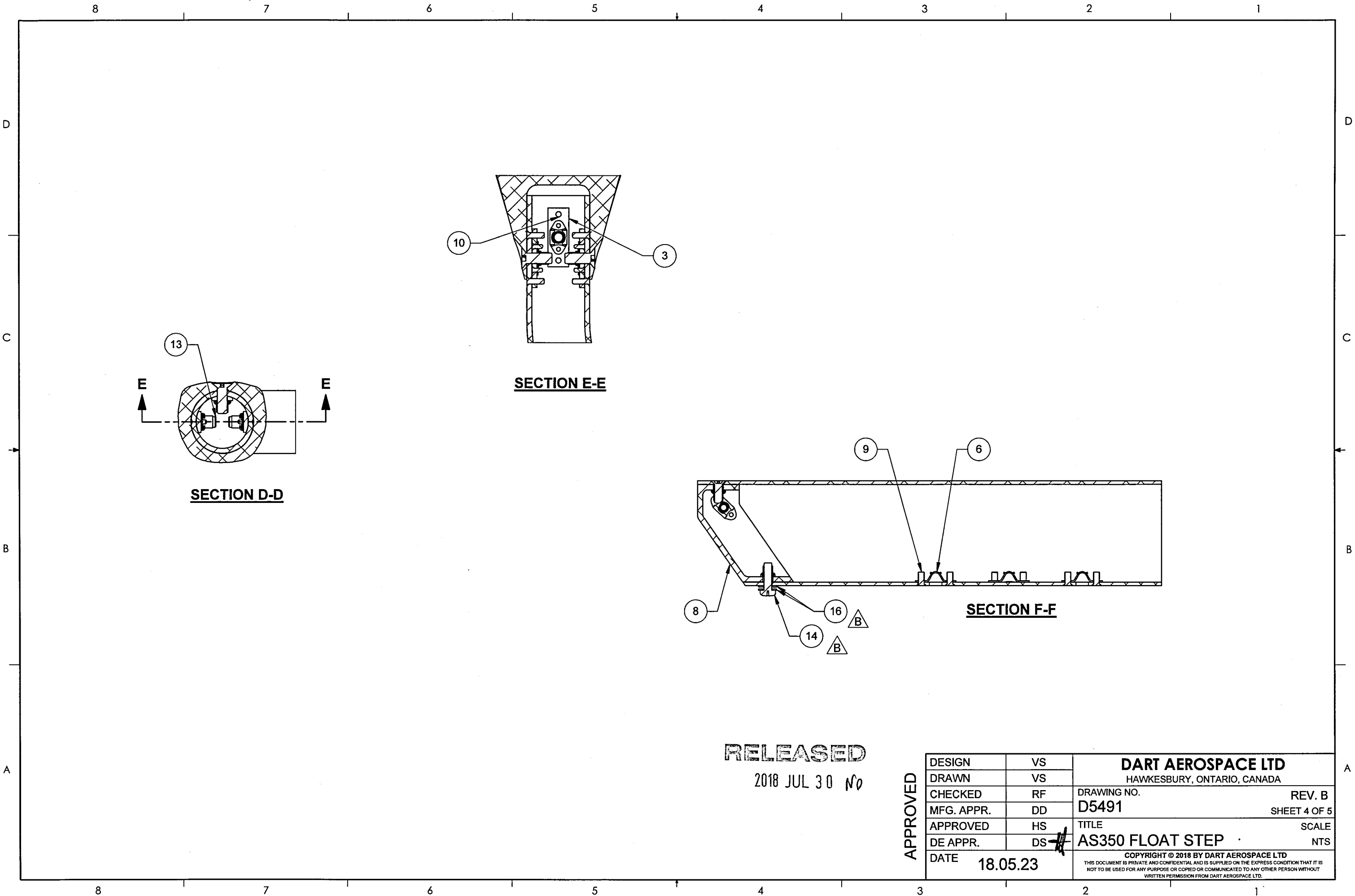
- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 AND PAINT PER DART QSI 005 4.2.2.4
MASK SCREWS, APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.80 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10384
- 9) TRANSFER DRILL FROM D5273-043 END FITTING ASSEMBLY TO D5627-1 TUBE
- 10) MASK SLOT PRIOR TO PAINT
- 11) INSTALL PLACARD IN ORIENTATION SHOWN ON BOTTOMSIDE OF STEP AFTER PAINTING

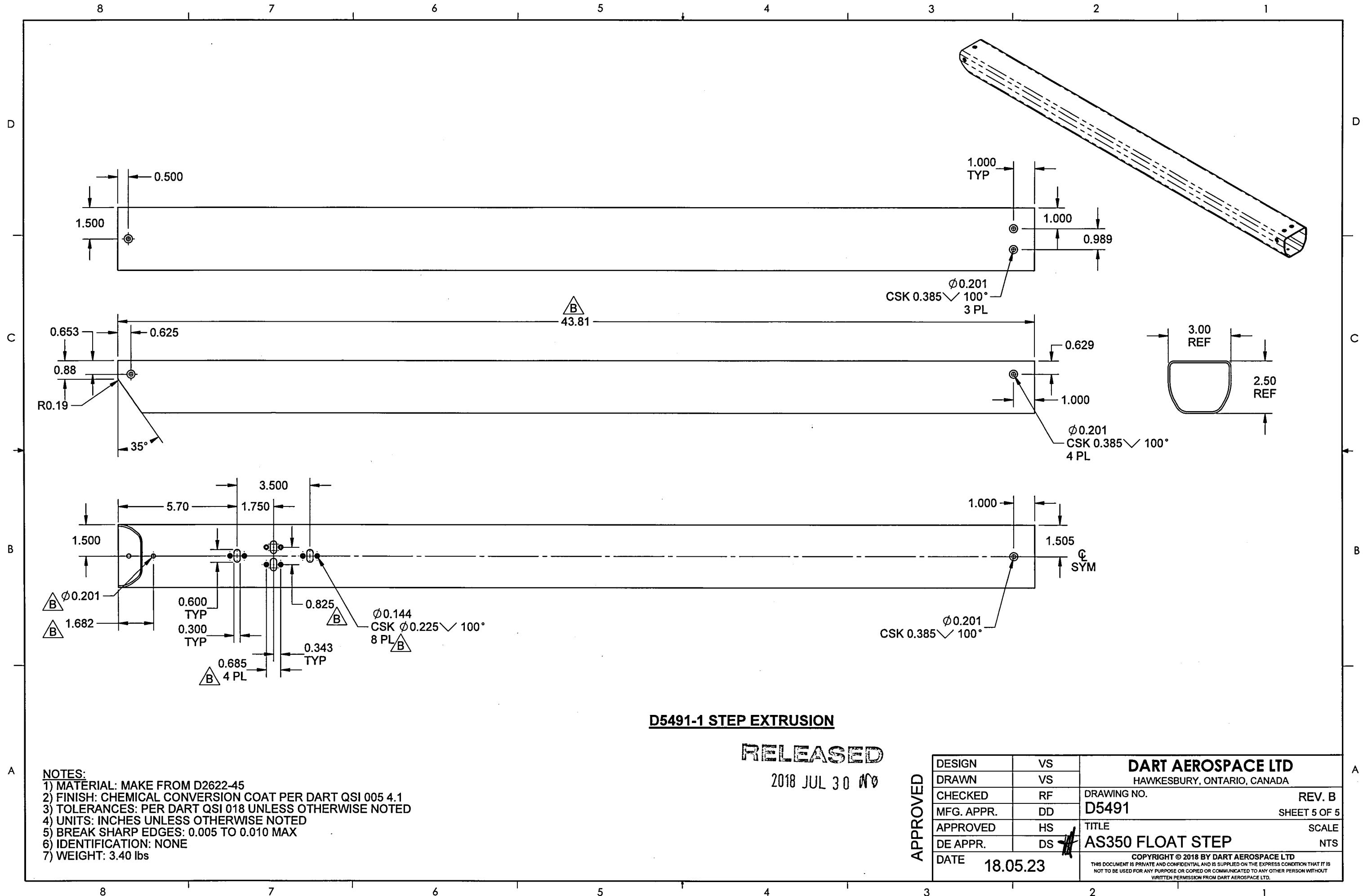
RELEASED

2018 JUL 30 W0

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5491	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AS350 FLOAT STEP	NTS
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D5491-1 STEP EXTRUSION

RELEASED

2018 JUL 30

- NOTES:
- 1) MATERIAL: MAKE FROM D2622-45
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 3.40 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5491	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AS350 FLOAT STEP	NTS
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